

Date: Thursday, 5/11/2006 10:41:13 AM  
 User: Kim Johnston

## Process Sheet

24

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 CARGO MIRROR  
 Job Number : 27068  
 Estimate Number : 10095  
 P.O. Number : N/A Part Number : D044715011  
 This Issue : 5/11/2006 S.O. No. : N/A Drawing Number : D3243REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 26137 Material : Manufacture in multiples of 10  
 Written By : SEE COMMENT BELOW Due Date : 6/15/2006 Qty: 12 Um: Each  
 Checked & Approved By : 06.05.11  
 Comment : Est Rev:A 04-02-18 New issue KJ/JLM  
 Est Rev:B 06-04-28 Manufactured on Water Jet JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

K-06-06-05

10

2.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.5359 sf(s)/Unit Total: 5.3592 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: M18556 (6)(12) #18556

SAD 06:05:15 12

3.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 06:05:15 12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 05 13

12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06-05-16 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: R44 CARGO MIRROR

Job Number: 27068

Part Number: D044715011

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Debut

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Bend as per Dwg D3243

SB

06/06/20

8.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

2006-21

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
1-Chemical Conversion Coat as per QSI 005 4.1

m.f. 06-06-21

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

SC 06/29/06

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/30

12.0 FE032EF Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch


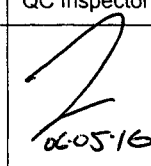
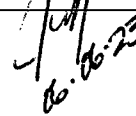
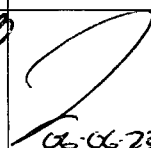
4 FE-032EF Insert

M18486 (16) M100895 (32)

1 D3243-1(Ref)

Bracket

627068

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-05-16	6	Remove. deburring at step. 3. After cutting. Permanent change.						
06-06-23	10 13	Install insert before paint. & step changes as shown. Permanent change.						

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: R44 CARGO MIRROR

Job Number: 27068

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

120  
11

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg d3243

FF 06-06-27 12

120  
12

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-27 (12)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

H 14 06-07-04

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
2 D1048 Clamp B24979 (19) B27091 (5)

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
2 D1049 Saddle B24980

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
1 D2010-104 Arm B25641x8 / B27279x4

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
1 D2011-101 Mirror B24967x6 / B27163x6

B27163x6  
B27163x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 27068

Part Number: D044715011

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 D3243041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch

1 D3243-041 Bracket ~~B21255~~ B27068 ✓

21.0 ALS41032130 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch

4 ALS4-1032-130 Insert M18293 ✓

22.0 AN34A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A Bolt M18310 ✓

23.0 AN526C1032R10 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw M14741 ✓

24.0 AN960JD10L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L Washer M101291 ✓

25.0 QC4 INSPECT 100% KITS FOR COMPLETENESS




Comment: INSPECT 100% KITS FOR COMPLETENESS

A.M 06-07-06 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA:  Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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Drawing Name: R44 CARGO MIRROR

Job Number: 27068

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location: REV A

*06/7/8 (12)*

27.0

DC

DOCUMENT CONTROL



*(12)*

Comment: DOCUMENT CONTROL

Inspection Level 21

*06/07/07*

Job Completion



*u 0607-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

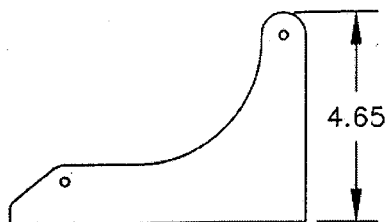
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09	TITLE BRACKET	SCALE 1:2	
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/  
D3243-041 ASSEMBLY  
SCALE 1:4

INSTALL  
FE-032-EF INSERTS  
(4 PLACES)

2.75  $\pm 0.030$   
0.000

11.920

11.420

Ø0.201  
(TYP 4  
PLACES)

Ø0.290  
(TYP 4  
PLACES)

1.375

5.273

3.714

0.500

0.000

8.581

8.206

7.706

4.214

R0.25 (TYP)

3.339

R0.38  
(TYP)

5.494

R2.75  
(TYP)

R0.50  
(TYP)

D3243-1  
FLAT PATTERN

RELEASED  
04.02.03

SHOP COPY  
TURN TO  
GRAIN  
DIRECTION  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27068

**D3243-041 BRACKET ASSEMBLY**  
**(D3243-1 BRACKET)**


- 1) MATERIAL: 6061-T6, 0.063 THICK  
(QQ-A-250/11, REF DART SPEC  
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO  
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

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Date: Thursday, 11/01/2007 2:52:48 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D044-715/D022-716 - ECN 900
Job Number	: 30248		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 11/01/2007 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 30247	Material	: N/A
Written By	: 	Due Date	: 18/01/2007 Qty: 1 Um: Each
Checked & Approved By	: _____		
Comment	: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

EASA STC EASA IM.R.S.01253

EASE STC EASA IM.R.S.01254

D044-715-011 B26137 1X B27068 10 B29561 4 (20)

D022-716-011 B21220 9X  7/6/12

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



 07.01.15